

Date: Thursday, 15/01/2009 12:36:35 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BO 105 SKIDTUBE ASSEMBLY
Job Number	: 44849		
Estimate Number	: 10119		
P.O. Number	:	Part Number	: D105674011WG
This Issue	: 15/01/2009 S.O. No. :	Drawing Number	: D2966 REV A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SKIDTUBES	Drawing Revision	:
Previous Run	: 44846	Material	:
Written By	:	Due Date	: 28/01/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>JLD 09.01.15</u>		
Comment	: Est Rev:A 04.07.07 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Handwritten: JLD 09/02/17



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D105-674-011 CHG002

2.0	D2962125	Outer Tube Extrusion
-----	----------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-125 Extrusion 17532*Handwritten: ET 09-01-21*

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Open holes to Ø5/16" (0.313"). Deburr holes.

Handwritten: } ET 09-01-21

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------



Comment: BENDING MACHINE

Bend tube as per program BO105 on CNC Bender and Dwg D2966. Use 5/16" locator pin on buggy "A".

Handwritten: ET 09-01-21

5.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185-1G

Handwritten: ET 09-01-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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2-Cut Aft end at 107.06" using DT8185D

3-Deburr ends

4-Drill Aft Cap holes using DT8678

5-Locate DT8679 with 1/8 clecos in Aft Cap holes. Ensure DT8679 is centered on Fwd end of tube and drill #40 Fwd bushing.

6-Clamp DT8679 to the tube. Drill all #30 wearplate and crossbolt holes.

7-Open Aft Cap holes using #6 drill

8-Open wearplate holes and two side holes to Ø19/64" (0.297") as per Dwg D2966-1.

9-Deburr holes.

10-Open remaining (16) crossbolt holes to Ø0.500

6.0

D2964

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2964

Cap

A/R

Aluminum Rod

214101

m110295/m109213

3 BE 09-1-29

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D2966 and QSI 004. Fill #40 Fwd cleco hole.

2-Grind Fwd Cap welds flush

8.0

QC5

INSPECT WORK TO CURRENT STEP

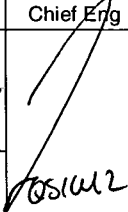
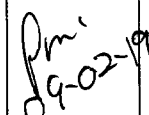
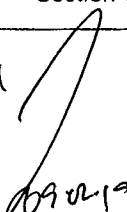

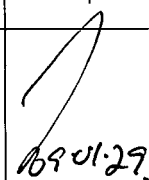


Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D105-674-011 WG PAR #: _____ Fault Category: _____ NCR: Yes No DQA: A Date: 09/02/25

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>44849</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-01-29	5.2	Tube was cut too short. Cut too 106.875" instead of 107.06" long. Tube was cut squared off on the cut line, not before the cut line. R.C: Human error.		Tube is acceptable. All hole locations are as per drawing, and length will not affect the tube.				

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Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 44849

Part Number: D105674011WG

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

SO 09/02/04

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DP

9-2-4

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 09/02/04

12.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to finish size as per Dwg D2966

2-Open 14 holes to Ø0.750" & 2 holes to Ø0.875", countersink crossbolt holes & remove alodine to prepare for welding as per Dwg D2966

3-Deburr holes inside & outside, blow out chips

DP 9-2-4

13.0

D2976

BO 105 Skidtube I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Numbe

Description Batch

1 D2976 Web

1344895

DP

9-2-4

14.0

D2971

Cross Bolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2971 Crossbolt Spacer

44445

BE 9-2-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 44849

Part Number: D105674011WG

Job Number:



Seq. #: Machine Or Operation: Description :

15.0

D2973

Cross Bolt Spacer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick:

Qty Part Number Description Batch

7 D2973 Crossbolt Spacer

814636

BE 09/02/05

16.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bond Web in place per QSI 015. (Ensure holes line up)

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

M109883

Sikaflex expiry date :

9-2-11

DP 9-2-4

2-Weld Crossbolt Spacers as per Dwg D2966 and QSI 004. For crossbolt spacer, weld one side, pass 5/8" drill; weld other side, pass 5/8" drill.

Pick:

Qty Part Number Description Batch

A/R

Aluminum Rod

M110225

BE 09/02/05

3-Pass Ø0.630" drill to remove spillover for D2973 crossbolt. Pass Ø0.750" drill to remove spillover for D2971 crossbolt.

BE 09/02/05

4-Grind welds flush as per Dwg D2966

BE 09/02/05

17.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/02/05 (XU)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/05 (XU)

19.0

POWDER COATING

POWDER COATING



Comment: HAND FINISHING RESOURCE #1

Powder Coat Gloss White as per QSI 005 4.3

START TIME:

12:50

pressure wash - M109996

FL 09/02/09 (P)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 44849

Part Number: D105674011WG

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 320°

FINISH TIME: 13:20

mo / FL 09/02/09^①

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



FL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-11

(X1)

21.0

D2965

Cap, 105 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2965

Cap

B45616

FL

22.0

D29701

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2970-1

Wearplate

B43726

FL

23.0

D29703

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2970-3

Wearplate

B43727

FL

24.0

D31761

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3176-1

Bushing

B35627

FL

25.0

D31763

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3176-3

Nut

B37585

FL 09/02/11^①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 44849

Part Number: D105674011WG

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

ALS71032130

Insert



Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number Description Batch

36 ALS7-1032-130 Insert m108606

or ALS4-1032-130

or AKS7-1032-130

or AKS4-1032-130

FL

27.0

AN960JD10L

Washer



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick:

Qty Part Number Description Batch

28 AN960JD10L Washer m109632

FL

28.0

MS27039108

Screw



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick:

Qty Part Number Description Batch

26 MS27039-1-08 Screw m110467

FL

29.0

MS27039109

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-09 Screw m18057

FL

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for foreign objects as per QSI 024

2-Install Inserts, Wearplate and Cap per Dwg D2966. Insert a drop of sikaflex at insert holes before installing wearplates. Seal Aft Cap using Sikaflex. Install bushing and nut. By looking Fwd, install nut to right hand side.

Pick:

FL 09/02/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 44849

Part Number: D105674011WG

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expiry date:

M109883
09/11

- FL 09/02/11 (1)

3-Wing Walk as per Dwg D2966 and QSI 0054.4

Batch: M110454

HL

09-02-11

(X)

31.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5 09/02/11 (X)

32.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*****ENSURE INSERTS ARE AT LOCATION (6) AS PER DWG D2966*****

5 09/02/11 (X)

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

34.0

D2972

Bushing



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

6 D2972

Bushing

14103

SS 09/02/11 (X)

35.0

D2974

Packer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2974

Packer

B29439

SS 09/02/11 (X)

36.0

D2975

Wearshoe



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2975

Wearplate

29538

SS 09/02/11 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 44849

Part Number: D105674011WG

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

AN451A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

3 AN4-51A Bolt

M109285

38.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD10L Washer

M109632

39.0

MS21042L4

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

3 MS21042L4 Nut

M109282

40.0

MS27039108

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 MS27039-1-08 Screw

M110552

41.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

109-02-19 (1)

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D105-674-011

Location:

Rev Draft 9/2/10

(K)

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 44849

Part Number: D105674011WG

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/22/2009

Job Completion



mf
09-02-19

44849

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2966	REV. A SHEET 1 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY	SCALE NTS
A	00.03.08	NEW ISSUE	

RELEASED
00.05.11 [Signature]

Qty	Part Number	Description
X	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
1	D3176-1	BUSHING
1	D3176-3	NUT

A2

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.6.1) PER DART QSI 005 4.3.6.2
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7)

A1

01.01.29
(p 01.01.30)

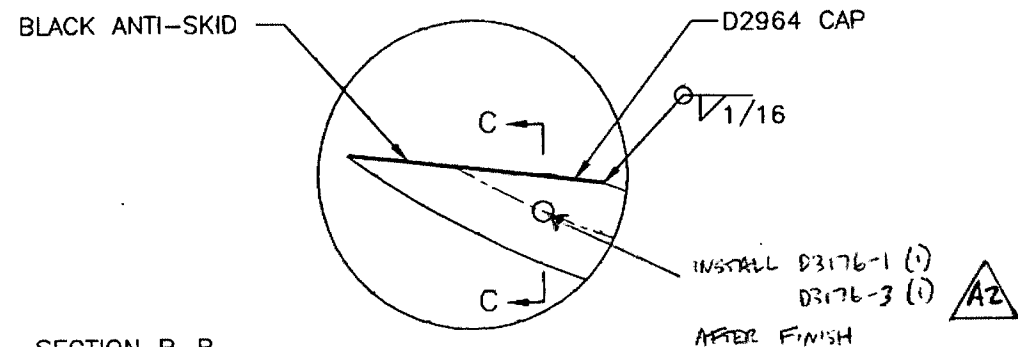
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NO. H4849

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A1	01.01.29	CHANGE COLOR TO BLACK SANDTEX	[Signature] UP

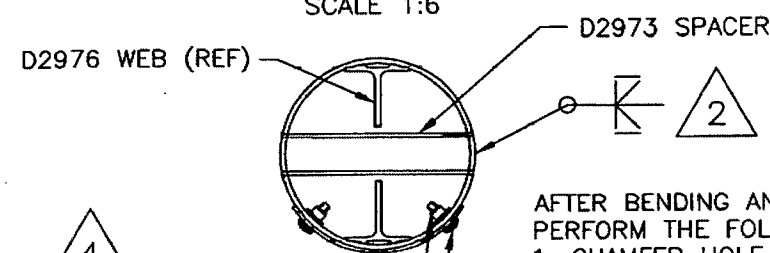
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DETAIL A
SCALE 1:3



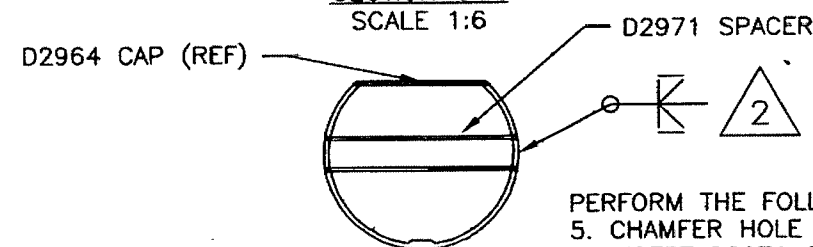
SECTION B-B
SCALE 1:6



- 4 ALS7-1032-130 INSERT (34 PLACES)
- 4 MS27039-1-08 SCREW (1)
- AN960JD10L WASHER (1) (26 PLACES)

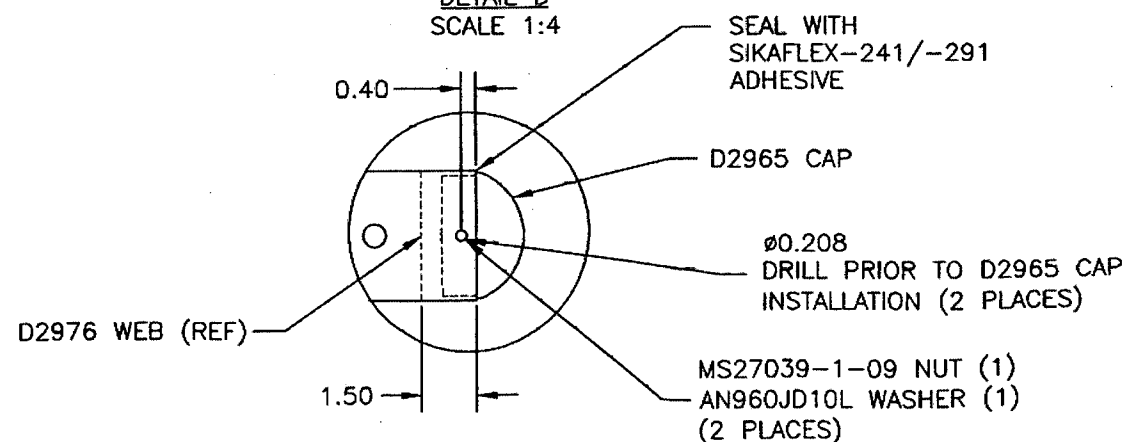
- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR $\phi 0.750$ HOLES ONLY:
1. CHAMFER HOLE $0.030 \times 45^\circ$
 2. INSERT D2973 SPACER (7 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS $\phi 0.630$ DRILL TO REMOVE SPILL OVER

SECTION C-C
SCALE 1:6

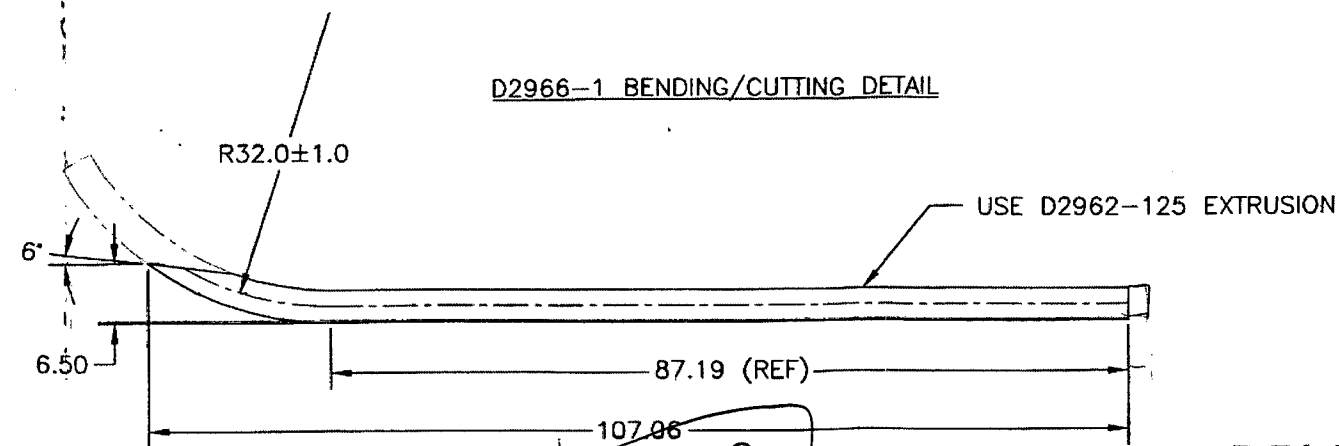


- PERFORM THE FOLLOWING FOR $\phi 0.625$ HOLES ONLY:
5. CHAMFER HOLE $0.030 \times 45^\circ$
 6. INSERT D2971 SPACER
 7. WELD INTO PLACE AND GRIND FLUSH
 8. PASS $\phi 0.484$ DRILL TO REMOVE SPILL OVER

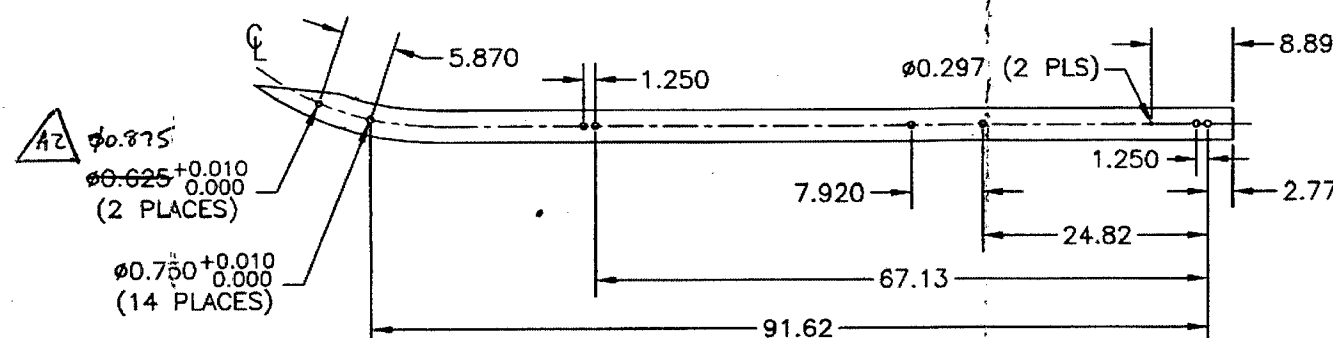
DETAIL D
SCALE 1:4



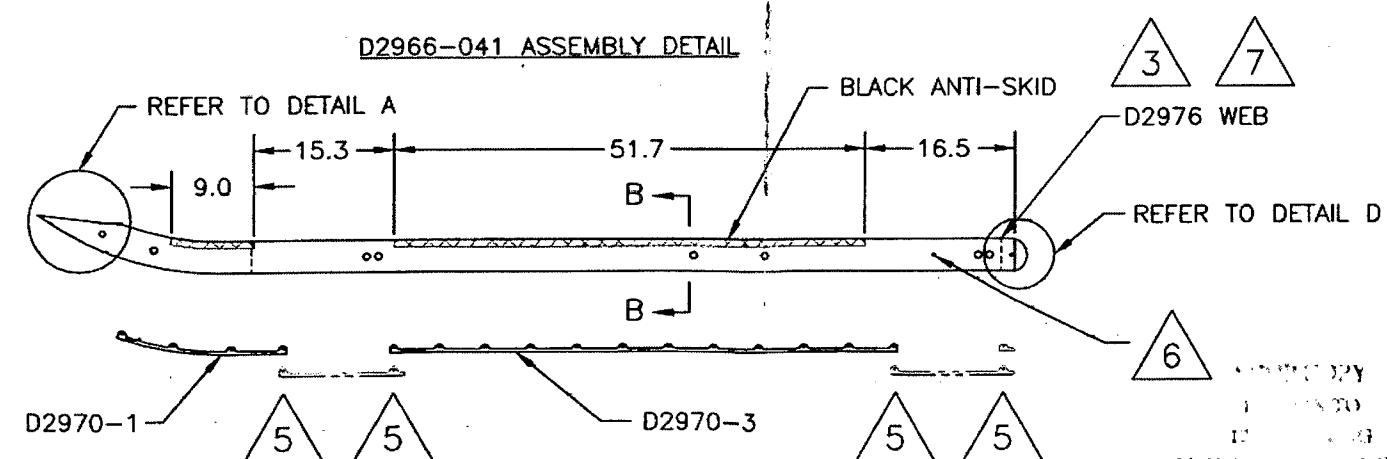
D2966-1 BENDING/CUTTING DETAIL



D2966-1 DRILLING DETAIL



D2966-041 ASSEMBLY DETAIL



RELEASED
00-05.11

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	CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	
	DATE	00.03.08	TITLE	BO 105 SKIDTUBE ASSEMBLY	
			DRAWING NO.	D2966	
					REV. A SHEET 2 OF 2 SCALE 1:20

NO 44819

NO. 192

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Bardley Elliot
Job number: 44849
Part number: D105 674 011 WC
Description: 60 105
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass ☒ fail ☐
pass ☒ fail ☐

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap):
Porosity (surface):
Coloration:

pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐

Qualifier Pet Duvel Date of Test Coupon 09-02-05
Welder Bardley Elliot Date of Test Coupon 09-02-05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld